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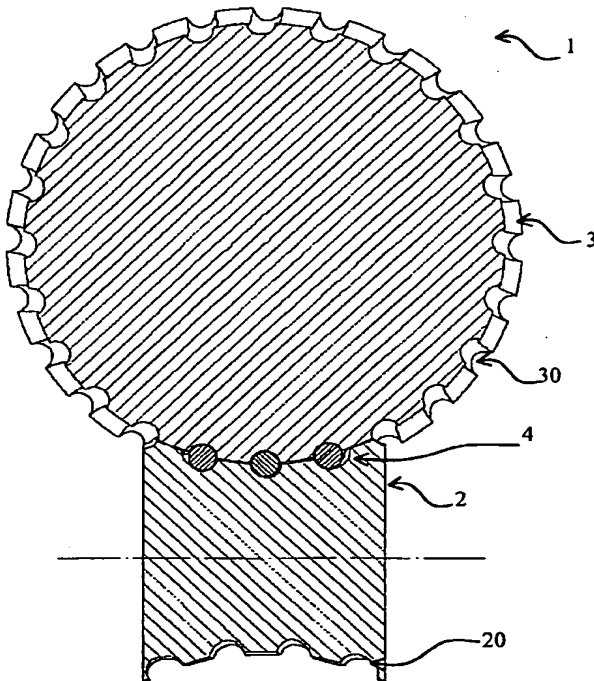
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[Continued on next page]

(54) Title: **METHOD FOR CUTTING WORM AND WORM GEAR IN A WORM AND GEAR REDUCTION UNIT WITH CIRCULATION OF BEARING BALLS AND RELATED CUTTING TOOLS**



(57) Abstract: A method for cutting worm and worm wheel in a worm-gear reduction unit (1) with circulation of bearing balls, comprising the steps of: (a) obtaining races (30) for the bearing balls (4) onto the worm wheel (3); and (b) obtaining races (20) for the bearing balls (4) onto the worm (2), wherein step (b) provides the cutting of the races (20) according to a cutting profile substantially corresponding to the envelope of the subsequent positions assumed by the bearing balls within the worm wheel races being formed.

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